



Dart Aerospace Ltd.
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Hawkesbury, ON
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5093792
D119-796-035
Job Sheet 180169



Part No: D119-796-035

Job Qty: 1 ea

Part Name: AW119 Landing Gear Assembly - Heavy-Duty, Run-on Landing Wearplates, Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/29/18

Job Tracking No:

Due Date: 8/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D119-796-035 REV B, IIN-D119-796 REV F IPP REV:A NEW ISSUE 15-05-13 JLM VERIFIED BY:DD
IPP REV:B 15.08.25 AS PER ECN15-580 DD VERF:JLM IPP REV:C 18.03.22 ADDED D5449-1 DD
VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/22/18	8/22/18	0.00	0.00	Start Up Stores/Pkg-1		AUG 08 2018
100	Packaging	1 pcs	8/22/18	8/22/18	0.00	0.00	Packaging1-1		AUG 10 2018
110	HandFinish	1 pcs	8/22/18	8/22/18	0.00	0.00	HandFinish4		AUG 08 2018
120	QC	1 pcs	8/22/18	8/22/18	0.00	0.00	QC5		38
125	Packaging	1 pcs	8/22/18	8/22/18	0.00	0.00	Packaging1-1		9-89
127	QC	1 pcs	8/22/18	8/22/18	0.00	0.00	QC4		DAS
130	Packaging	1 pcs	8/22/18	8/22/18	0.00	0.00	Packaging3-1		21
140	QC21-FG	1 Ea	8/22/18	8/22/18	0.00	0.00	QC21		AUG 10 2018

Part Op 100 - Photocopy bluefile and create labels as per PPP D119-796-035 chg 004/ D119-646-243 paperwork.
Descriptions: 110 - ASSEMBLE AS PER DWG AND NOTES 8,9,10,11 ASSEMBLE WITH PROSEAL BATCH: 138 348-INSTALL
DECAL D2729-4
130 - Identify and pack for shipping as per PPP D119-796-035 Location: _____ PPP Rev: _____
Exp 11/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C46A	Bolt	8 Ea (8 ea)	90-Start up Operation	5100743
AN3C50A	Bolt	16 Ea (16 ea)	90-Start up Operation	5100744
AN4C6A	Bolt	24 Ea (24 ea)	90-Start up Operation	5100745
D119-646-243	AW119 Repl. Skidtube with Heavy Duty Wearplates, Float Compatible -Fits LH or RH	2 Ea (2 ea)	90-Start up Operation	5100746
D119-796-151	Fwd Crosstube Installation With Step (No Hardware)	1 Ea (1 ea)	90-Start up Operation	5099020
D119-796-251	Aft Crosstube Installation With Step (No Hardware)	1 Ea (1 ea)	90-Start up Operation	5099012
D2652	Bushing 5054607 x16	48 Ea (48 ea)	90-Start up Operation	5100746
D3407-041	Tow Ring	2 Ea (2 ea)	90-Start up Operation	5100747
D3417-5	Washer	4 Ea (4 ea)	90-Start up Operation	5100748
D3456-1	Washer	2 Ea (2 ea)	90-Start up Operation	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval					
Description Work Order Deviation			Disposition						
			Completed By						
			hand / Supervisor roval Verification						
			QA Coordinator Approval						
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>			Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	FAULT CATEGORY <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%; vertical-align: top;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> </table>			Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐								
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OTHER :			Misaligned/off center ☐ Misread ☐ Turning Sequence ☐ ed Wrong ☐ Dimensions ☐ order tolerance ☐ rrect ☐ /Missing ☐ ed ☐						

DART AEROSPACE
 Container No: S100896
 Part: D119-796-035
 Job No: 180169
 Serial No/Batch: S100896
 Revision: B / F
 Inspector:
 Exp Date:
 Instructions: TC STC SH14-45- Issued: 6/11/12, EASA

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D3672-3	Washer, Phenolic	48 Ea (48 ea)	90-Start up Operation	5100749
D3672-7	Washer, Phenolic	48 Ea (48 ea)	90-Start up Operation	5100750
D3883-1	Saddle, Outboard LH	2 Ea (2 ea)	90-Start up Operation	5100751
D3883-2	Saddle, Outside RH	2 Ea (2 ea)	90-Start up Operation	5100752
D3884-1	Saddle, Inside LH	2 Ea (2 ea)	90-Start up Operation	5100753
D3884-2	Saddle, Inside RH	2 Ea (2 ea)	90-Start up Operation	5100754
D3886-041	Lug Assembly	4 Ea (4 ea)	90-Start up Operation	5100755
MS21043-3	Nut	24 Ea (24 ea)	90-Start up Operation	5100756
MS21043-4	Nut	26 Ea (26 ea)	90-Start up Operation	5100757
MS21043-5	Nut	8 Ea (8 ea)	90-Start up Operation	5100758
MS21250-05048	Bolt (Use Ms21250-05-048)	8 Ea (8 ea)	90-Start up Operation	5100759
NAS1149C0332R	Washer	24 Ea (24 ea)	90-Start up Operation	5100760
NAS1149C0432R	Washer	48 Ea (48 ea)	90-Start up Operation	5100761
NAS1149C0532R	Washer	16 Ea (16 ea)	90-Start up Operation	5100762
D5449-1	Float Saddle Washer	4 Ea (4 ea)	90-Start up Operation	5100763
MS21920-28	Clamp	2 Ea (2 ea)	125-Packaging	5100711 B149905

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C46A	8	122	0
	AN3C50A	16	159	0
	AN4C6A	24	317	0
	D119-646-243	2	0	0
	D119-796-151	1	1	0
	D119-796-251	1	0	0
	D2652	48	389	0
	D3407-041	2	18	0
	D3417-5	4	19	0
	D3456-1	2	306	0
	D3672-3	48	1,099	0
	D3672-7	48	561	0
	D3883-1	2	5	0
	D3883-2	2	5	0
	D3884-1	2	11	0
	D3884-2	2	14	0
	D3886-041	4	20	0
	D5449-1	4	1	0
	MS21043-3	24	1,125	0
	MS21043-4	26	401	0
	MS21043-5	8	166	0
	MS21250-05048	8	36	0
	NAS1149C0332R	24	5,075	0
	NAS1149C0432R	48	1,715	0
	NAS1149C0532R	16	217	0
125-Packaging	MS21920-28	2	41	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Disassembly Strip Back

Container No: S093792

Action: Tear Down

Strip Back To Operation:

Search

Quantity	Name	Part No	Revision	Operation Code	Disposition
Tear Down Serial No: S093792 to					
	OLD	NEW		Disassemble	
8 Bolt	S024836	S100743	AN3C46A	Start up Operation	Disassembly ▾
16 Bolt	S079135	S100744	AN3C50A	Start up Operation	Disassembly ▾
24 Bolt	S027515	S100745	AN4C6A	Start up Operation	Disassembly ▾
48 Bushing	S054607	S100746	D2632	Start up Operation	Disassembly ▾
2 Tow Ring	S080752	747	D3407.041	Start up Operation	Disassembly ▾
4 Washer	S089808	748	D3417.5	Start up Operation	Disassembly ▾
2 Washer	S079335	749	D3456.1	Start up Operation	Disassembly ▾
48 Washer, Phenolic	S027022	750	D3692.3	Start up Operation	Disassembly ▾
48 Washer, Phenolic	F157442	751	D3672.7	Start up Operation	Disassembly ▾
2 Saddle, Outboard LH	S081617	752	D3883.1	Start up Operation	Disassembly ▾
2 Saddle, Outside RH	S081399	753	D3883.2	Start up Operation	Disassembly ▾
2 Saddle, Inside LH	S079480	S049936	D3884.1	Start up Operation	Disassembly ▾
2 Saddle, Inside RH	S080306	754	D3884.2	Start up Operation	Disassembly ▾
4 Lug Assembly	S072751	755	D3886.041	Start up Operation	Disassembly ▾
24 Nut	S062620	757	MS21043.3	Start up Operation	Disassembly ▾
26 Nut	S062296	758	MS21043.4	Start up Operation	Disassembly ▾
8 Nut	S024470	759	MS21043.5	Start up Operation	Disassembly ▾
8 Bolt (Use MS21250-05-048)	S076013	760	MS21250-05048	Start up Operation	Disassembly ▾
24 Washer	S049837	761	NAS1149C0332R	Start up Operation	Disassembly ▾
48 Washer	S050052	762	NAS1149C0432R	Start up Operation	Disassembly ▾
16 Washer	S055951	763	NAS1149C0532R	Start up Operation	Disassembly ▾